

SPC/CT

Date: Thursday, 10/19/2006 2:50:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CÜ-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT BRACKET	
Job Number	: 29078		Part Number	: D23625	
Estimate Number	: 11856		Drawing Number	: D2362 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/19/2006 S.O. No. : N/A		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/27/2006 Qty: 12 Um: Each	
Previous Run	: N/A				
Written By	:				
Checked & Approved By	:				
Comment	: Est: D 00.04.24 Removed P/O from powder coat EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2265	Step Support Casting
<b>Comment:</b> Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Step Support Pick: Qty Part Number Description Batch 1 D2265 Step Support B 29079		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> Machine per folio D2362-5 Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> Inspect Level 2		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK		
5.0	POWDER COATING	POWDER COATING
<b>Comment:</b> POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/11/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/20	#20	one part scrap. holes for 0.257" x 0.75" slot Drilled in wrong location.	<u>DB</u> 06/11/20	Fix program D0362-5 Scrap / destroy and replace	<u>Er</u> 06/11/20	<u>2</u> 06/11/20	<u>DB</u> 06/11/20	<u>2</u> 06/11/20
06/11/20	#20	one part scrap. moved out of pocket when drilling operator error	<u>DB</u> 06/11/20	Scrap / destroy / replace Remind operator to pay more attention	<u>Er</u> 06/11/20	<u>2</u> 06/11/20	<u>DB</u> 06/11/20	<u>2</u> 06/11/20

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 29078

Part Number: D23625

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SB

06/11/21

(12)

7.0 D23975

Rubber Cushions



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1 D2397-5

Rubber

B8952

SB

06/11/21

(12)

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-5 using contact cementas per Dwg D2362

SB

06/11/21

(12)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/21

(12)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51/72

SB 06/11/22

(12)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/23

(12)

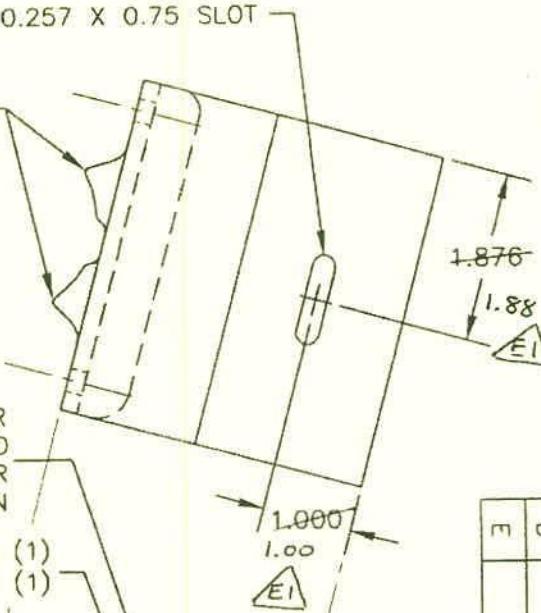
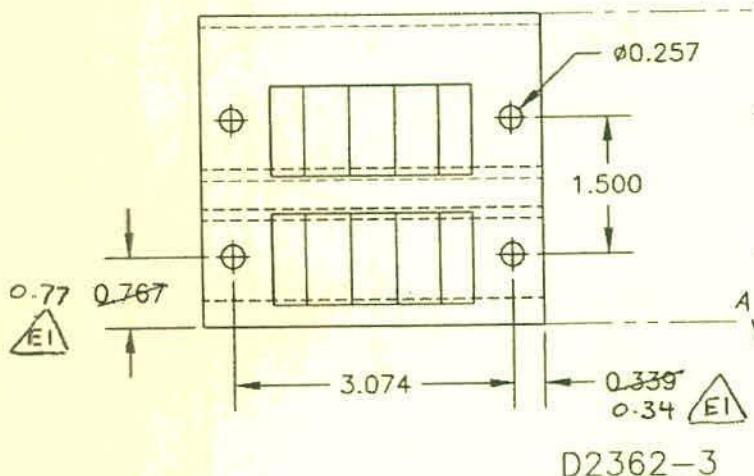
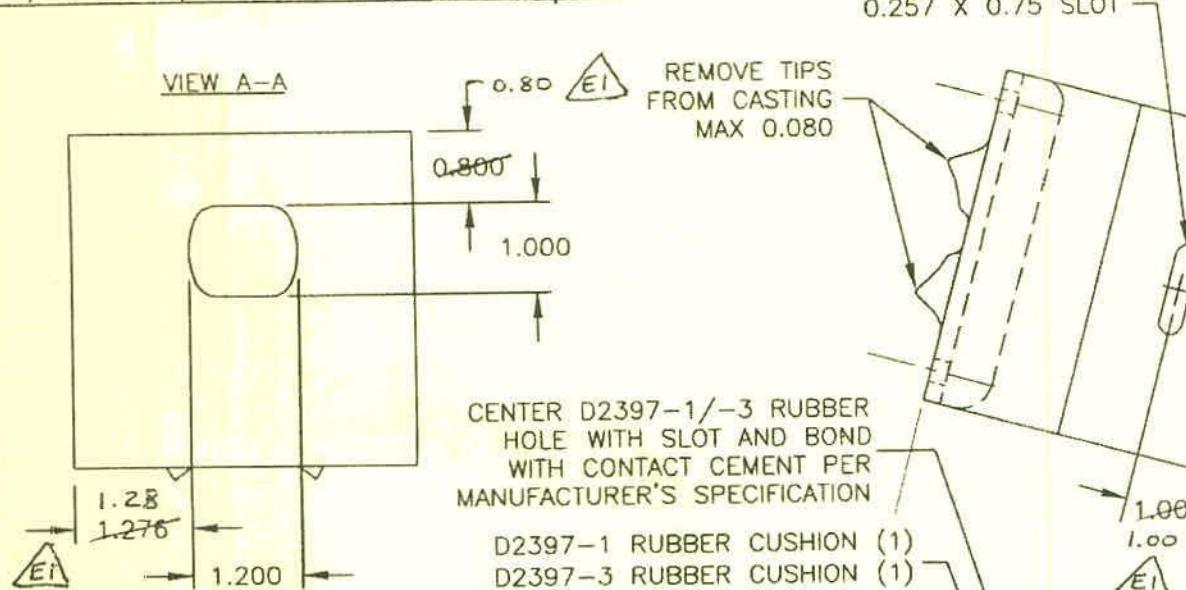
Job Completion



06/11/23



EI 03.10.07 TOLERANCE CHANGE **REF**



**RELEASED**  
98.12.14 **KE**

**DART**  
© DART

DESIGN BW	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <b>KE</b>	APPROVED <i>W</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 1 OF 3 SCALE 1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

**UNDER REVIEW**

12/10/98 CP

DESIGNOK, BUT CHECK WITH  
3P BEFORE MANUFACTURE

OK for 11.09

SHOP DRAWN  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK OF DART  
NO. 29018

**NOTES:**

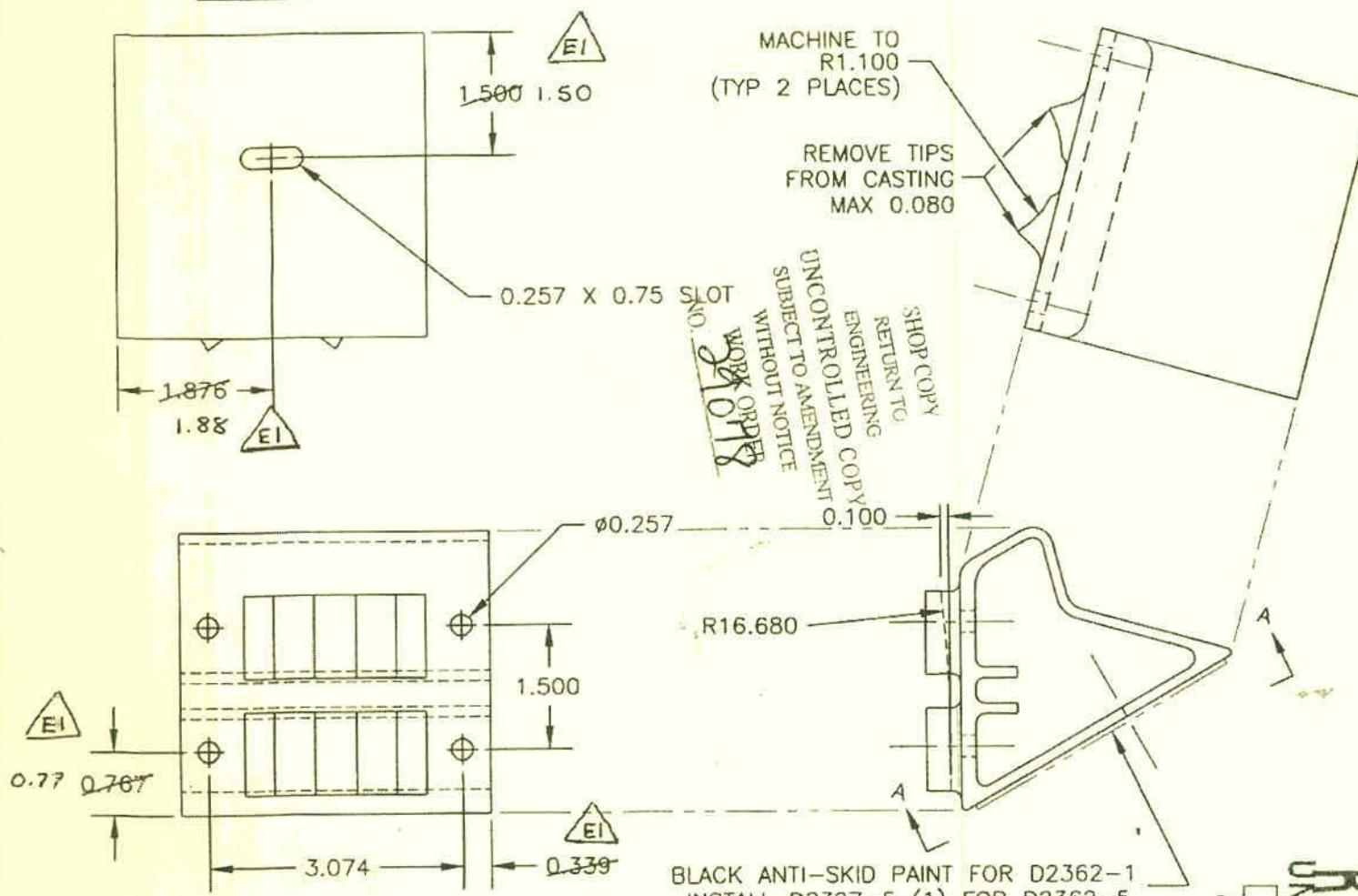
MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



VIEW A-A



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>RE</i>	<i>MM</i>	D2362
DATE		STEP SUPPORT BRACKET
98.12.04		
SCALE		
SHEET 2 OF 3		
REV. E		

**RELEASED**  
12-14-98  
UNDER REVIEW  
2003-05-09  
Design ok, but check w/  
3B before manufac.  
OK (P.M. 109)



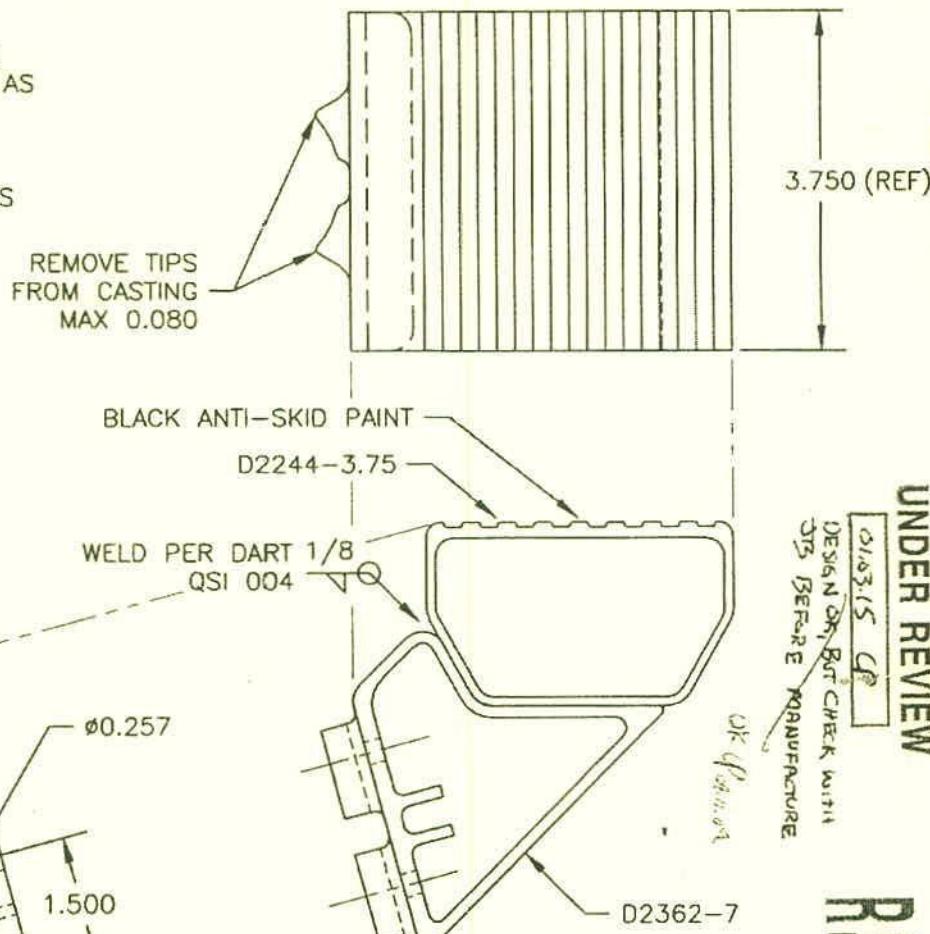
D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PLATE PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 241078

DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED RE	APPROVED MM	REV. E
DRAWING NO. D2362		SHEET 3 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2

UNDER REVIEW  
01/03/95 CP  
RELEASED  
4/12/98 LE

OK (P.M. 10/98)



DART AEROSPACE LTD	Work Order:	29678
Description: Support Bracket.	Part Number:	D2362-5
Inspection Dwg: D2362 , Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Measured by:	C.P	Audited by:	J.L	Prototype Approval:	
Date:	06/11/17	Date:	06/11/17	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

